

Date: Monday, 3/13/2006 7:30:54 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 26216		
Estimate Number	: 10600		
P.O. Number	: N/A	Part Number	: D2519
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Number	: D2519 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 4/7/2006
Checked & Approved By	: <u>06.03.13</u>	Qty:	100 Um: Each
Comment	: Est: B 00.03.18 Re-format, laser cutting EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 799

Laser cut as per Dwg D2519

Material release note required

U. 06.03.15

2.0	D2519F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
 - Clamp

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

100  
 06/04/07

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK  
 (8.561" center to center)

06.04.12

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr any rough edges after tumbling

2-Bend as per Dwg D2519

SAD

06.05.02

100

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *PD*   Date: 06/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 26216

Part Number: D2519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06-05-03 100*

Comment: INSPECT WORK TO CURRENT STEP

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

*540 06:05:03 (100)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *50/180*

*06/05/08 (100)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06-05-08 (100)*

Job Completion



*06-05-08*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

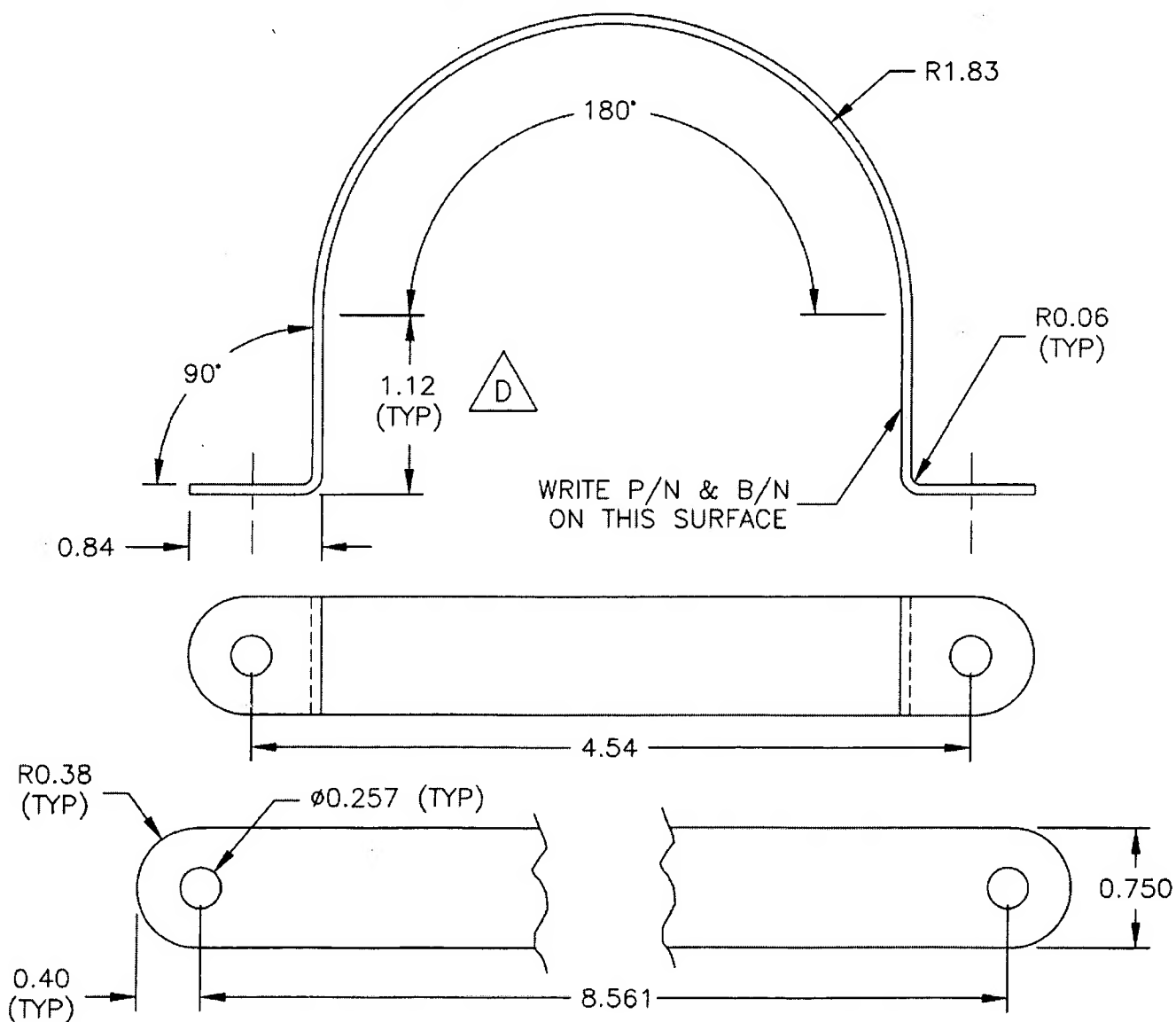
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART****RELEASED**  
04.11.26

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED H	DRAWING NO. D2519	REV: D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

**D2519 FLAT PATTERN**

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

### LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 7 FEVRIER 2006

Company Name: G.F.I. Division of Thomas & Betts limited  
Address: 180 avenue Labrosse  
City: Pointe Claire, Qué.  
Zip Code: H9R 1A1

# du client: 68417

# de commande SSMQ: 851031  
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	10	062" X 48" X 96"	304 2B		533008

Bien à vous,  
Yours truly,

Commis à l'administration.  
Administration Clerk.

✓  
AS  
06/04/07

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5  
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399  
FAX: 514-457-9393

LET. DE. COM 12/01/C



**UGINE & ALZ**  
Groupe Arcelor

UGINE & ALZ France

Immeuble 'La Pacific'

11/13, cours Valmy - La Défense 7

92800 PUTEAUX FRANCE

Tél. +33 1 41 25 60 20 Télécopie +33 1 41 25 60 07

NIP : FR67383719085

**PACKING LIST  
TEST REPORT**

**No 82794**

Mill Ref : SUAS29275 04

Page : 1 / 1

Your REF : SAMUEL C97613 304/304L 2B

Date : 06 Oct 2005

Agent's Ref : 48 WIDE COIL

Our REF : 05130F035919/82794 References to quote

SEE ADDRESS OPPOSITE

Sold To :

**SAMUEL ET FILS LTEE**  
2225 FRANCIS HUGUES

**H7SINS LAVAL CANADA**

Ship to :

**SAMUEL ET FILS LTEE**  
2225 FRANCIS HUGUES

**H7SINS LAVAL CANADA**

06102005	Customer	Invoiced	Agent's No	Country	O/A leadtime	File/Load Doc	Dispatch From ISBERGUES	Invoice
151316	60158	60158	572/****	056	Sept 2005	73206/75233	(BONCOURRE REYNALDE)	20051035919

By :  
Shipping Agent:  
TMFOPERATING  
Instructions :

DDP3 MTR (Delivered Duty and Taxes includ. MONTREAL )  
Forwarding Agent :  
OCEAN LOGISTICS

Number of parcels : 2

Mill Ref : I44210

Type of order : N

UGINOX 18-9 L COLD ROLLED 2B FINISH

STEEL COILS AISI304L

Edges CIS

Marks : P.O. C97613 AISI304/304L 2B 0,059" X 48" X COIL

Item No	Lot No	Packing No	Size/Dimensions	Thickness	Quantity	Net Weight In Kg	Gross Weight In Kg	Net Weight Lbs	Tare Lbs
1	63190	L7011	1219,20						
			48" X 0,059"	1,490	212				
1	63190	L7014	1219,20						
			48" X 0,059"	1,490	212				
Total per item 1 ( Complete )					2	11120	11186	24516	146
Packing list total					2	11120	11186	24516	146

( Certificate requested )

Mill Ref. / Item	Lot No	Heat No	C %	Si %	Mn %	Ni %	Cr %	Mo %	Ti %	N %	CU %	S %	P %
I44210/1	63190	533008	0,022	0,49	1,49	8,02	18,06			0,060	0,240	0,002	0,027

Mill Ref. / Item	Lot No	Heat No	(I)	YS PSI	YS PSI	Elongation 80mm	Elongation 2"	Hardness	GG	ERICH	Bend	Responsible Quality Control
I44210/1	63190	533008	T	94105	45530	48	48	85HRB				M. THOMAS

REMINDER Our deliveries are subject only to our general conditions of export sale as listed on the reverse of our order acknowledgement which has been sent to you and stipulating more particularly a clause on the TRANSFER OF PROPERTY

(1) Tran/Long

UGINE & ALZ France s.a. au capital de 355.067.728 EURO - R.C.S. Numéro 343 719 089 Siège social : Immeuble 'La Pacific' 11/13, cours Valmy - La Défense 7 - 92800 PUTEAUX FRANCE

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

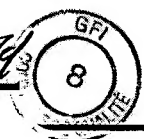
**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>1</u>	OUR JOB NO	<u>J0140800</u>	SHIPPING MEMO	<u>0334319</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	<u>100 PCS</u>	<u>PO00000799</u>	<u>D2519F</u>	<u>D</u>	<u>CLAMP</u>	<u>D</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>S.S.T 304</u>		<u>SAMUEL / UGINE &amp; ALZ</u>		<u>533008 ATT'D</u>		
	PROCESS		PROCESSOR	RELEASE NOTE #		
1	<u>6-04-11</u>					
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 05 APRIL 2006

G.F.I. Q.C. REP. Darren Hord



*AP 06/04/07*